

Work Order ID 58088

April 22, 2010 2:55:24 PM



Page 1

Item ID: D3852-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 22/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: *H*

Date: *10-4-22* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

- 1- pick D3166-3 to cut D3852-1 rib (LH) as per dwg D3852 using DT9440 jig
- 2- drill hole (3/16") in D3852-1 using DT9439 jig and open to finish size as per dwg D3852
- 3- c/sink hole as per dwg
- 4- remove identification markings
- 5- deburr
- 6- weld D3759-1 bushing as per dwg D3852
A/R ER316 S.S. Rod Batch: *111679*
- 7- grind bushing weld flush as per dwg dwg D3852
- 8- deburr hole if necessary

3AD 10-05-05

Q

10-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

② PD 10.05.06

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S. d. l. o. l. o. c.

②

-041

150



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

Memo

0.00

SAD
10-05-06

②

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Page 3

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Customer:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/07 *[Signature]*
mf
10-5-6

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April 22, 2010 2:55:28 PM

Page 1

Work Order ID: 58088

Parent Item: D3852-041

Parent Item Name: Rib Assembly

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Start Date: 22/04/2010

Required Date: 29/04/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3166-3		Manufactured	No			100	Each	11.6211	0.3789			
---------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Basket Hoop

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

11.62112105

55697

2.1053E-05

56426

5.6211

57504

6

0.3789

D3759-1

Manufactured No

100

Each

21.0000

2.0000



Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

21

54072

9

57595

12

B57852 → ②

SAD 10-05-05

CP 10-05-05

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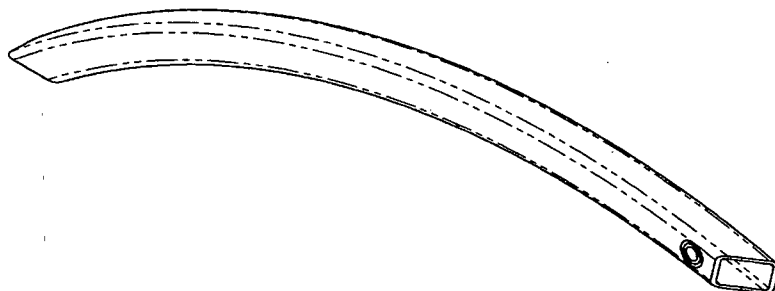
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



D3852-041 RIB ASSEMBLY



D3852-042 RIB ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58088

BS-0-4-22

RELEASED
08/11/07 MDP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.83 lbs EACH
 - 8) WELDING: PER QSI 004

A	NEW ISSUE		MB	08.11.07
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.11.07			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852** REV. A
SHEET 1 OF 3
TITLE **RIB ASSEMBLY** SCALE NTS

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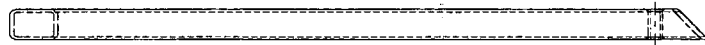
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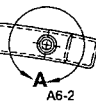
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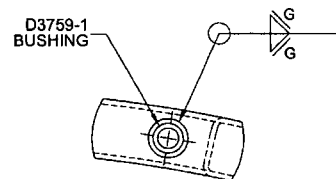
NOTE: Date & initial all entries



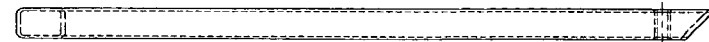
D3852-1
RIB



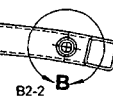
D3852-041 RIB ASSEMBLY



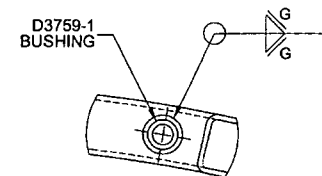
DETAIL A
SCALE 2X C5-2



D3852-2
RIB



D3852-042 RIB ASSEMBLY



DETAIL B
SCALE 2X C2-2

w/o 58088

RELEASED
08/11/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	125	DRAWING NO.	REV. A
MFG. APPR.		D3852	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
DATE	08.11.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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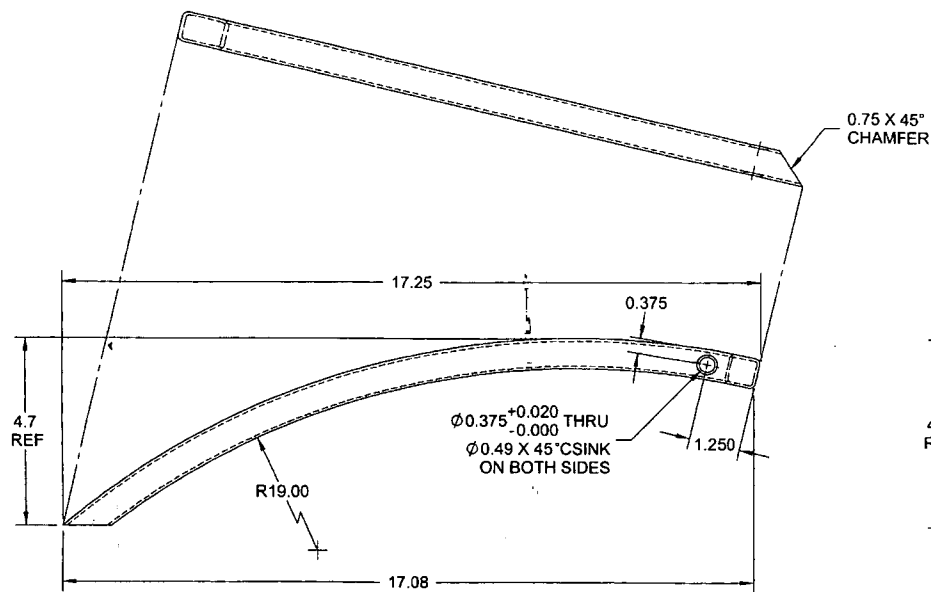
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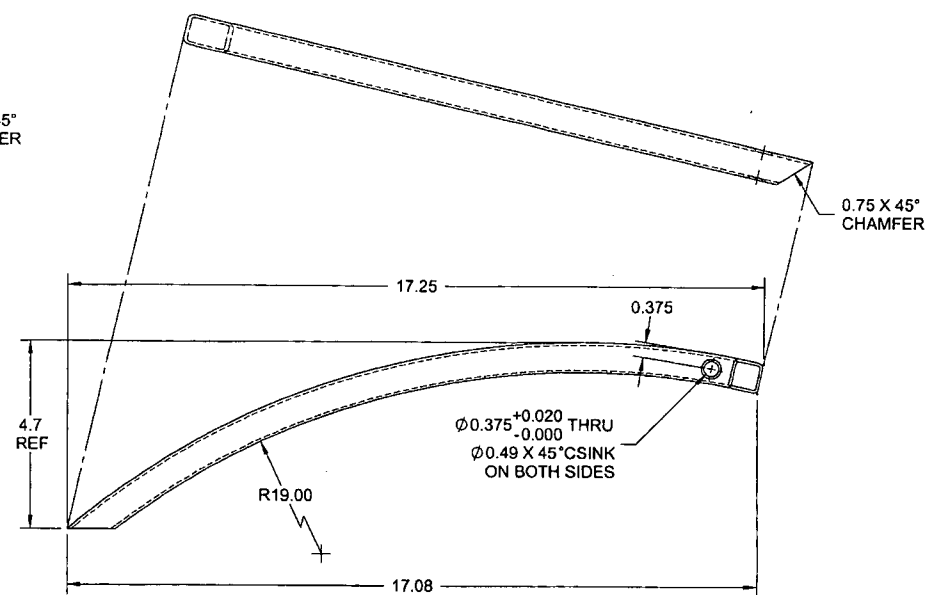
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D3852-1 RIB



D3852-2 RIB

w/o 58088

RELEASED

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3852	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSEMBLY	NTS
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